

Work Order ID 140053

Thursday, December 17, 2015 3:41:40 PM

140053

Page 1

Item ID: D5155-11 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Co-Pilot Collective Head (212)
 Start Date: 12/17/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/17/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: DEC 18 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5155	B								

100 Cut blanks as per folio 0.00
100
 Bandsaw Memo 0.00 B.a 16/01/06 4 0 **DAS**
 Jeaspa Bandsaw CUT BLANK AT 4.900" **08**
9-89

110 0.00
110
 HAAS 5AXIS Memo 0.00 B.a 16/01/06 4 0 **DAS**
 HAAS CNC vertical machine #5 MACHINE AS PER DWG & FOLIO FB349/ D5155-11 **08**
 FOLIO REV: AA **9-89**
 DWG REV: B

DO NOT BUFF OR POLISH PART

DEBURR

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
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Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
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Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
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Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order update only ☐

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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
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Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
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Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : ☐						
Misidentified ☐	☐	Past Due ☐							

Work Order ID 140053***140053***

Page 4

Thursday, December 17, 2015 3:41:40 PM

Item ID: D5155-11 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Co-Pilot Collective Head (212)
Start Date: 12/17/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 12/17/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>STISS</u>	0.00							
160									
Packaging	Memo	0.00				<u>4</u>		<u>MLJ</u>	<u>16-02-24</u>
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MLJ FEB 2 5 2016

MLJ FEB 2 5 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
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Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

Thursday, December 17, 2015 3:41:39 PM

Page 1

Work Order ID: 140053

140053

Parent Item: D5155-11

D5155-11

Parent Item Name: Co-Pilot Collective Head (212)

Start Date: 12/17/2015

Required Date: 12/17/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV.A NEW ISSUE JFS 15/01/14 VERIFIED BY: JLM IPP REV:B
15.07.02 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased		No		100	f	18.5000	0.409	1.722105			

M6061T6B2 500X03 500

6061-T6 Bar 2.50 x 3.50

B. 16/01/06

Location

Loc Qty

Loc Code

MAT004

18.5

m132320

0.5

→ m132772

6

m133265

12

1.65 ft

DQA: _____ Date: _____



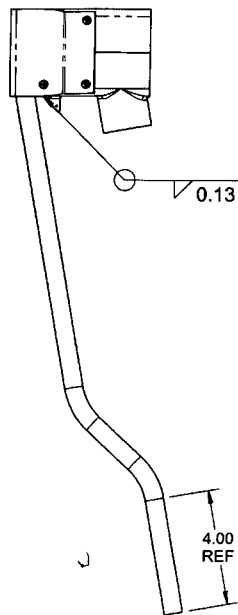
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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Root Cause		FAULT CATEGORY																							
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐		Positioned Wrong ☐															
Design ☐		Operator ☐		Bending ☐		Set-up ☐		Folio/Program ☐		Outside Dimensions ☐															
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Grain ☐		Over/Under tolerance ☐															
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Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐		Finish ☐															
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐		Misread ☐															
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐		Turning Sequence ☐															
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____																					
Misidentified ☐		Past Due ☐																							

ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-041	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)
2	1	D4410-7	CONDUIT
3	1	D5155-1	CO-PILOT COLLECTIVE HEAD (205)
4	1	D5155-9	CO-PILOT COLLECTIVE HEAD (205)
5	1	D5156-9	BACK PLATE
6	11	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	2	MS16562-223	SLOTTED SPRING PIN
8	7	MS24693-24B	SCREW, CSK 100*

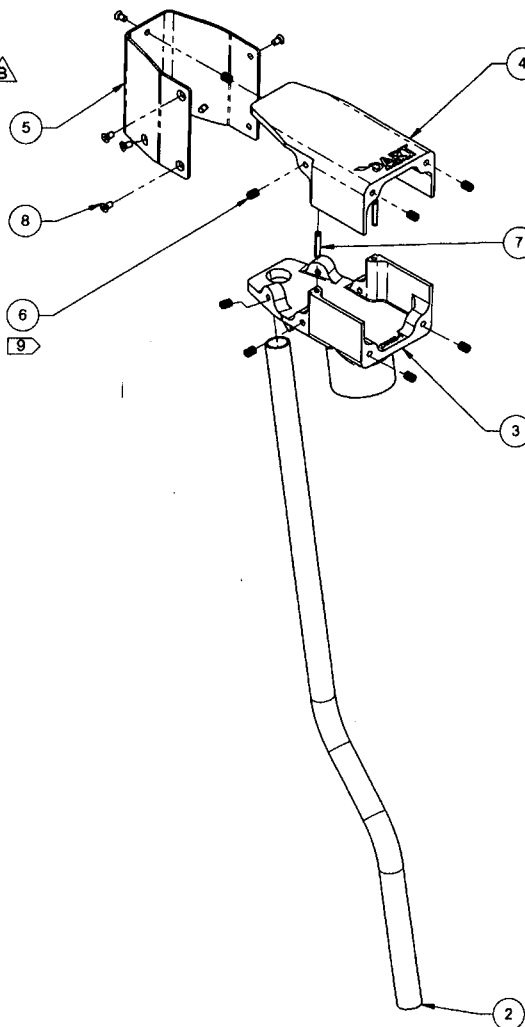


D5155-041 WELDING DETAIL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.08 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

D5155-041 CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)



SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 140053 M.C.S.
15-12-18

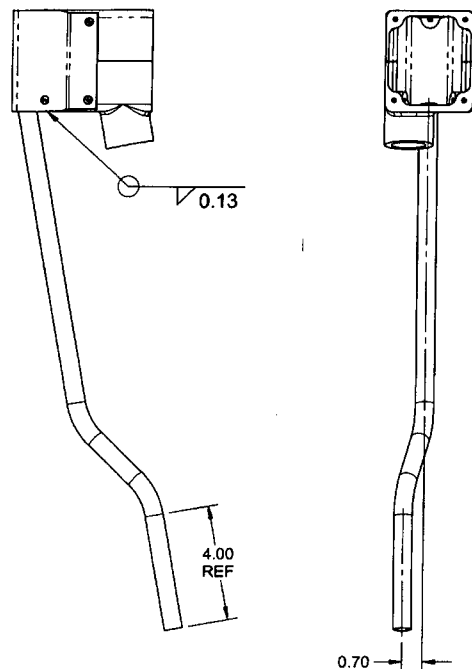
RELEASED

A.P. 2015 JUL 02 REV 15-577

B	REVISE DIM: ZN D3-7, REVISE NOTE 2; ZN A8-13, A8-14, REVISE LENGTH OF PIN: ZN D6-1, D6-2, D5-3, D6-4, REVISE DEPTH: ZN C7-5, C7-7, C7-9, C7-11, C5-13, C4-14, REVISE DIM: ZN C7-5, C7-7, C7-9, C8-11, B7-13, B7-14, B2-5, B2-7, B2-9, B2-11, C5-13, C4-14, D8-6, D8-8, D8-10, D5-6, D5-8, D5-10, D5-12, B8-7, D7-12, C7-5, C7-7, C7-9, C6-11, D2-13, D2-14	VS	15.05.21
A	NEW ISSUE	VS	14.09.10
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 1 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-043	CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)
2	1	D4410-7	CONDUIT
3	1	D5155-3	CO-PILOT COLLECTIVE HEAD (212)
4	1	D5155-11	CO-PILOT COLLECTIVE HEAD (212)
5	1	D5156-11	BACK PLATE
6	11	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	2	MS16562-223	SLOTTED SPRING PIN
8	7	MS24693-24B	SCREW, CSK 100°

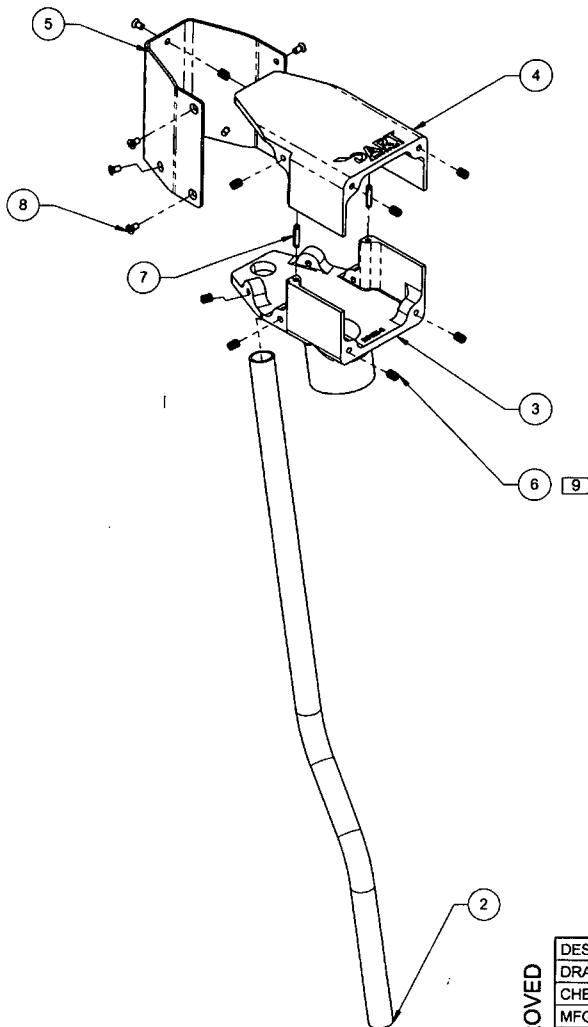


D5155-043 WELDING DETAIL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.20 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

D5155-043 CO-PILOT COLLECTIVE HEAD ASSY (212)



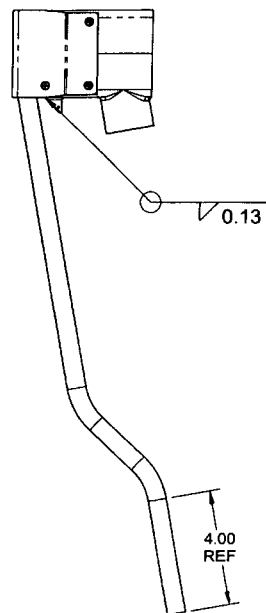
RELEASED

A.4. 2015 JUL 02

APPROVED

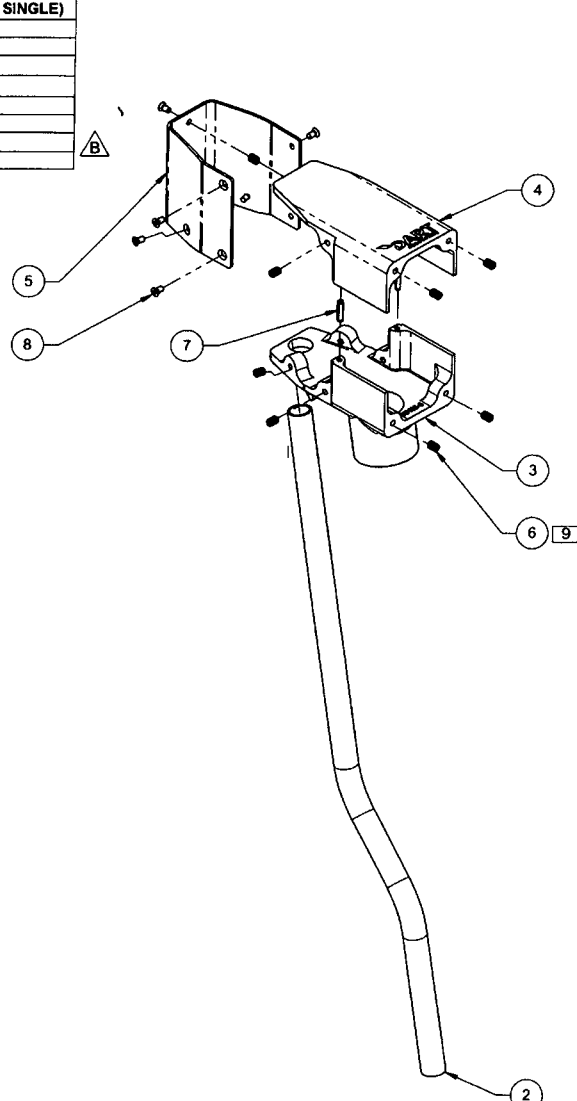
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 2 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-045	CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)
2	1	D4410-7	CONDUIT
3	1	D5155-5	CO-PILOT COLLECTIVE HEAD (EAGLE SINGLE)
4	1	D5155-9	CO-PILOT COLLECTIVE HEAD (205)
5	1	D5156-9	BACK PLATE
6	11	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	2	MS16562-223	SLOTTED SPRING PIN
8	7	MS24693-24B	SCREW, CSK 100°



D5155-045 WELDING DETAIL

0.27



D5155-045 CO-PILOT COLLECTIVE HEAD ASSY (EAGLE SINGLE)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.06 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

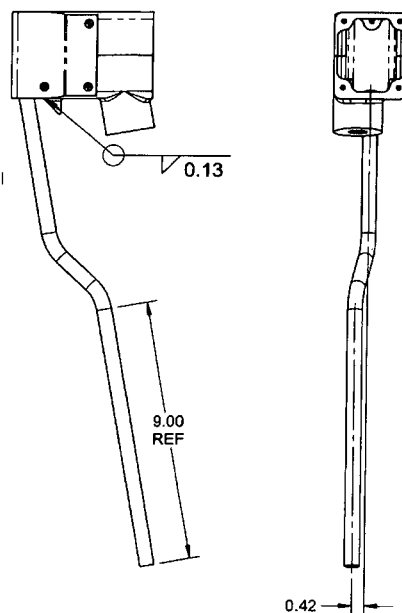
RELEASED

A.E 2015 JUL 02

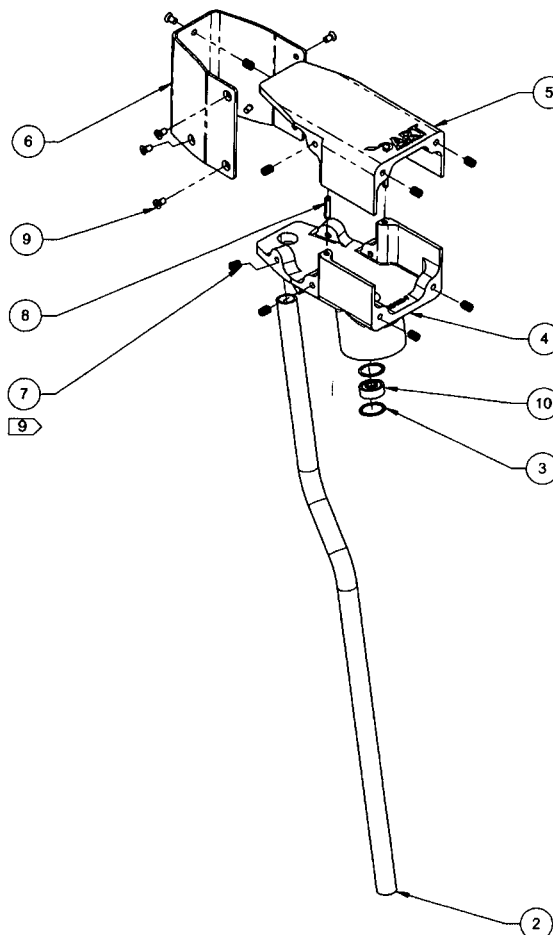
APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 3 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-047	CO-PILOT COLLECTIVE HEAD ASSEMBLY
2	1	D5054-1	CONDUIT
3	2	D5073-1	SNAP RING
4	1	D5155-7	CO-PILOT COLLECTIVE HEAD (205)
5	1	D5155-9	CO-PILOT COLLECTIVE HEAD (205)
6	1	D5156-9	BACK PLATE
7	11	90296A108	HELI-COIL INSERT (6-32 X 0.276)
8	2	MS16562-223	SLOTTED SPRING PIN
9	7	MS24693-24B	SCREW, CSK 100°
10	1	MS27641-3	BEARING



D5155-047 WELDING DETAIL



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.14 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

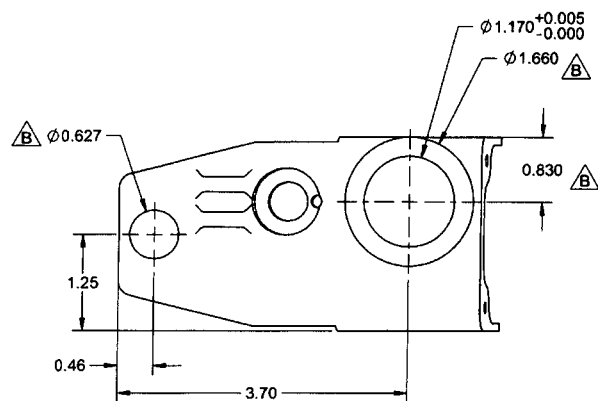
**D5155-047 CO-PILOT COLLECTIVE HEAD ASSY
FOR 205 WITH 204-001-290-5 STICK AND THROTTLE ASSEMBLY INSTALLED**

APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 4 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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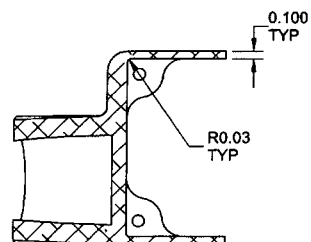
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A-9 2015 JUL 02



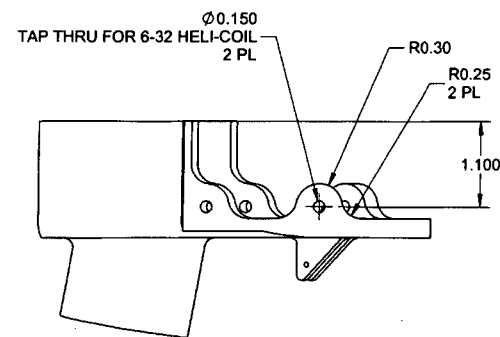
VIEW B-B

B5-5



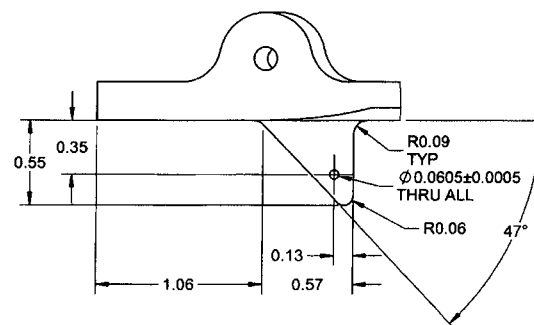
SECTION D-D

D6-5



VIEW C-C

D7-5



DETAIL E

B7-5

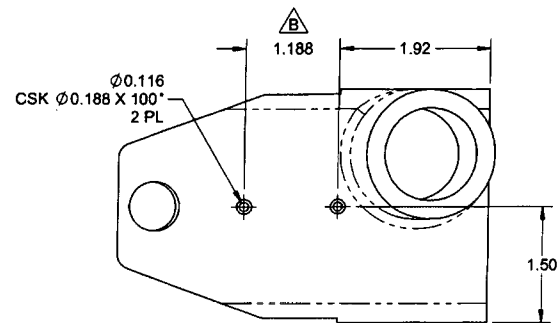
RELEASED
A.E. 2015 JUL 02

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

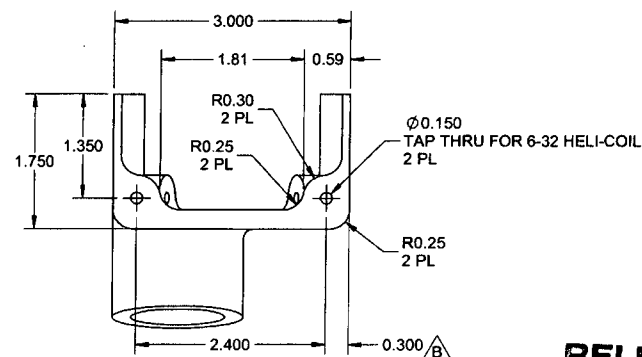
D5155-1 CO-PILOT COLLECTIVE HEAD (205)
DETAIL VIEWS

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 6 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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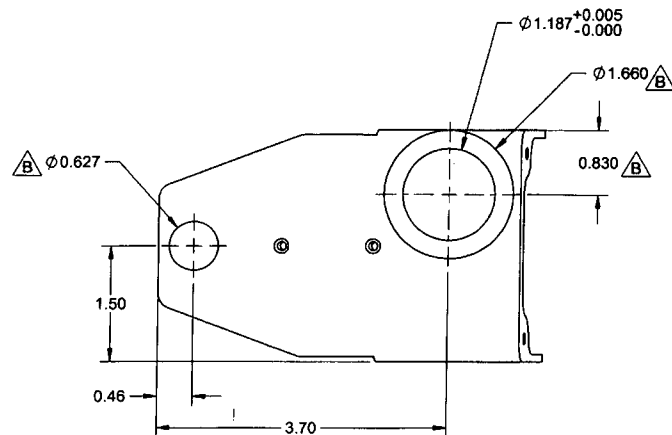


B7-7

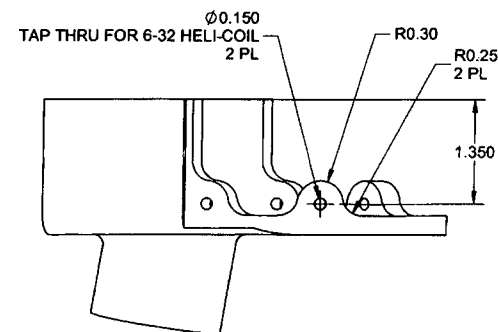


A.P. 2015 JUL 02

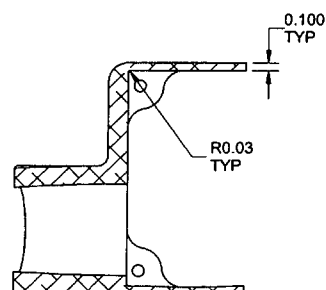
DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 7 OF 11
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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VIEW G-G
B6-7



VIEW H-H
D7-7



SECTION I-I
D6-7

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

D5155-3 CO-PILOT COLLECTIVE HEAD (212)
DETAIL VIEWS

RELEASED
A.9.2015 JUL 02

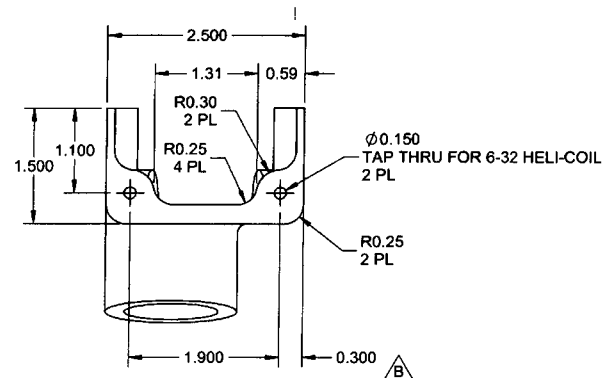
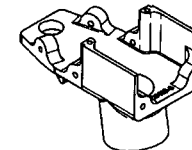
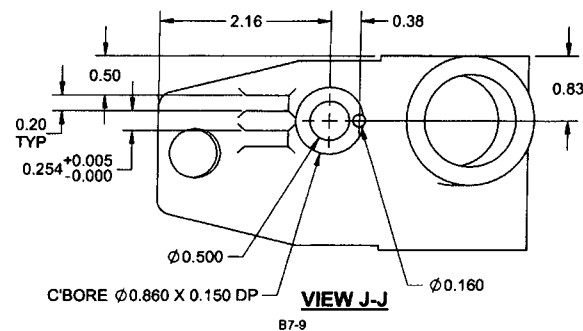
APPROVED

DESIGN	VS
DRAWN	VS
CHECKED	RF
MFG. APPR.	JFS
APPROVED	HS
DE APPR.	DS
DATE	15.05.21

DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	REV. B
D5155	SHEET 8 OF 14
TITLE	SCALE
CO-PILOT COLLECTIVE HEAD	NTS

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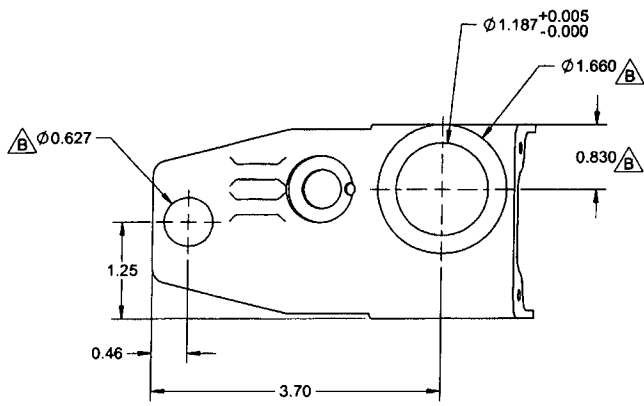
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A.O. 2015 JUL 02

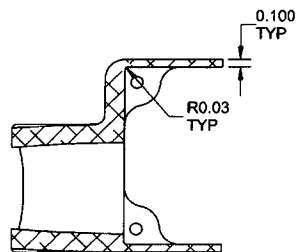
D5155-5 CO-PILOT COLLECTIVE HEAD (EAGLE SINGLE)

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D1515 REV. B SHEET 9 OF 11 SCALE NTS COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. ANY SUPPLY OF THIS CONFIDENTIAL DOCUMENT THAT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.
DRAWN	VS	
CHECKED	RF	
MFG. APPR.	JFS	
APPROVED	HS	
DE APPR.	DS	
DATE 15.05.21		CO-PILOT COLLECTIVE HEAD



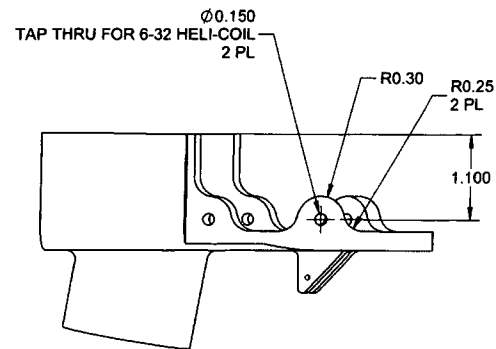
VIEW K-K

B6-9



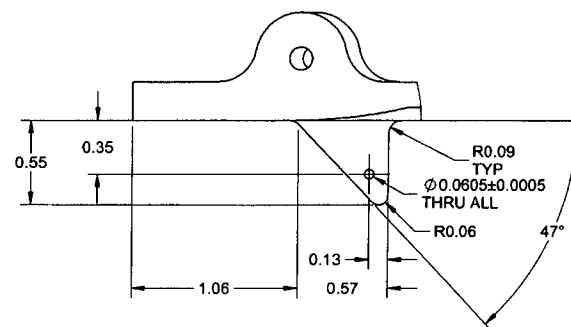
SECTION M-M

D6-9



VIEW L-L

D7-9



DETAIL N

B7-9

RELEASED

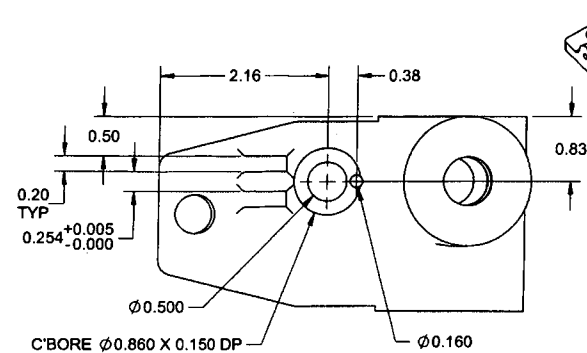
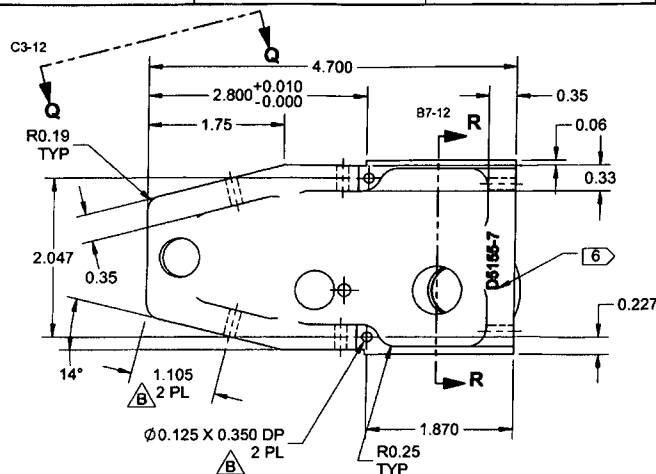
4.2. 2015 JUL 02

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

D5155-5 CO-PILOT COLLECTIVE HEAD (EAGLE SINGLE)
DETAIL VIEWS

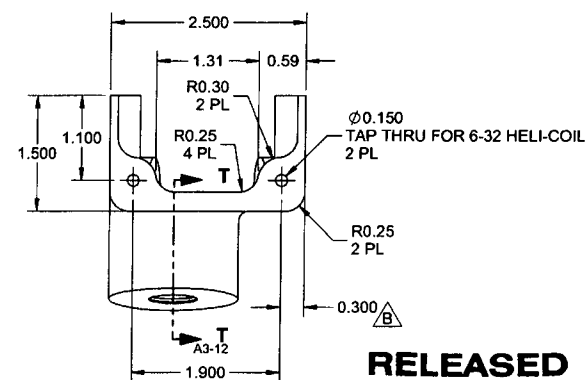
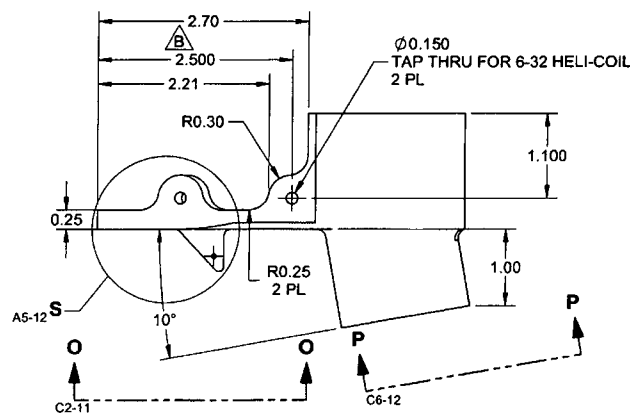
APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 10 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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VIEW O-O

B7-11



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A.P. 2015 JUL 02

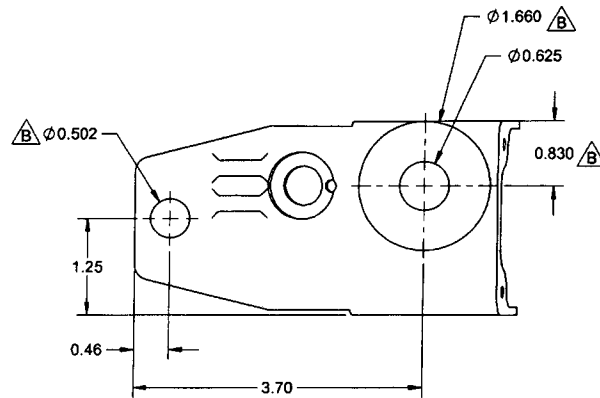
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.56 lbs
- 8) UNDIMENSIONED FEATURES DEFINED BY D5155-7.SLDPRT

D5155-7 CO-PILOT COLLECTIVE HEAD (205)

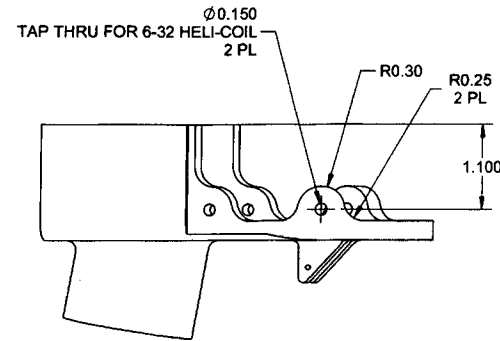
APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	JFS	D5155	SHEET 11 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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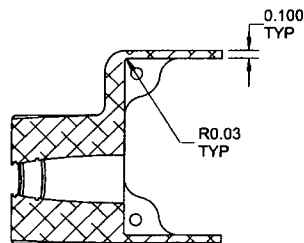
VIEW P-P

B5-11



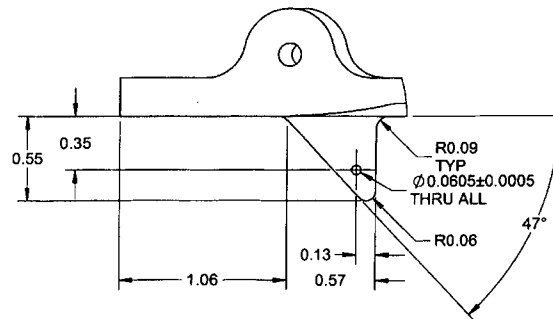
VIEW Q-Q

D7-11



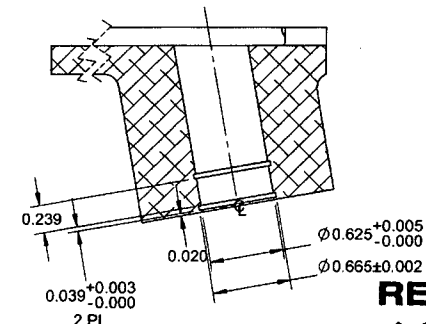
SECTION R-R

C6-11



DETAIL S

B6-11



SECTION T-T

B2-11

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A.R. 2015 JUL 02

NOTES:

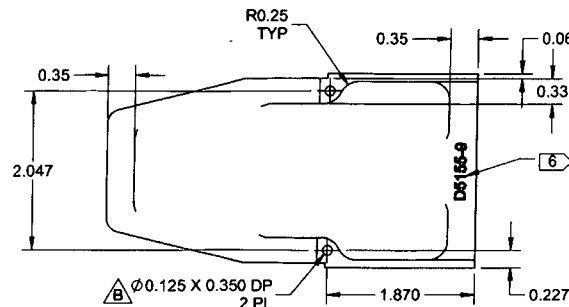
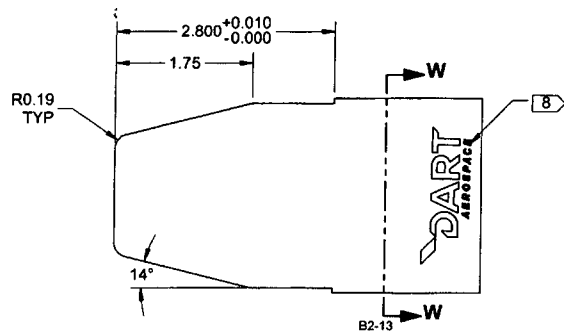
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

D5155-7 CO-PILOT COLLECTIVE HEAD (205)

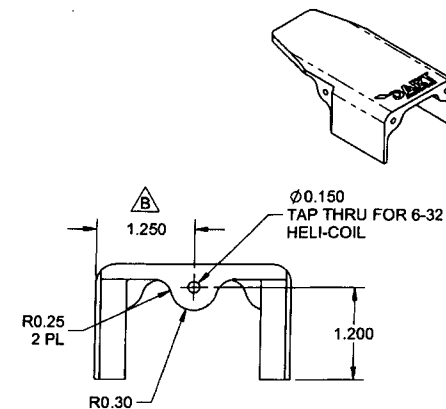
DETAIL VIEWS

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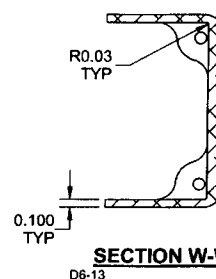
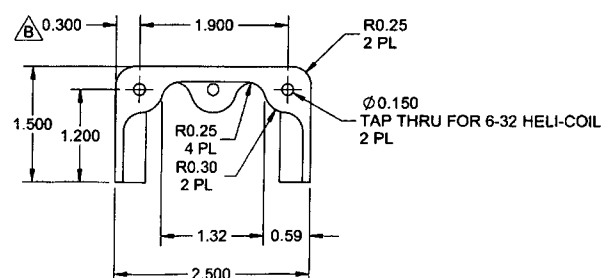
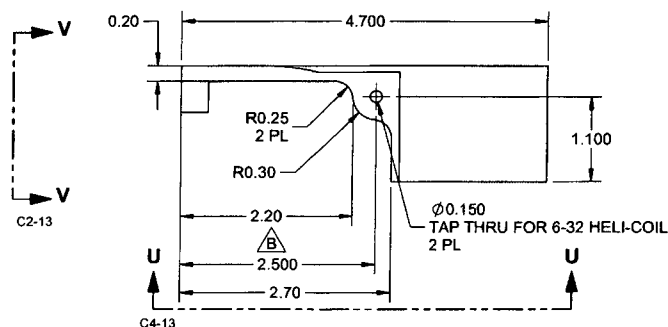
DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 12 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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VIEW U-U
B7-13



VIEW V-V
B8-13



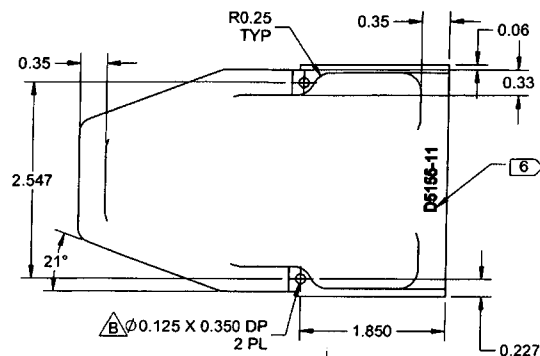
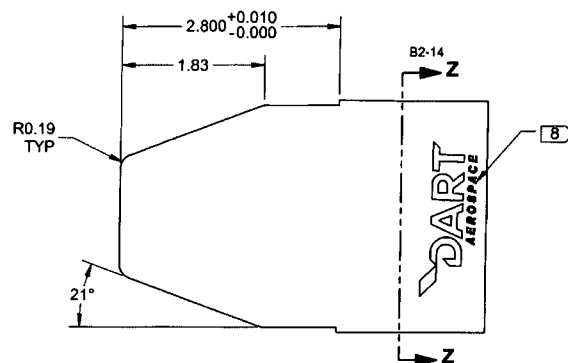
RELEASED
4.8.2015 JUL 02

- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
 - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II
OR IIB CLASS 2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
 - 7) WEIGHT: 0.31 lbs
 - 8) ENGRAVE "DART" LOGO AS SHOWN 0.003-0.005 DP
 - 9) UNDIMENSIONED FEATURES DEFINED BY D5155-9.SLDPRT

D5155-9 CO-PILOT COLLECTIVE HEAD (205)

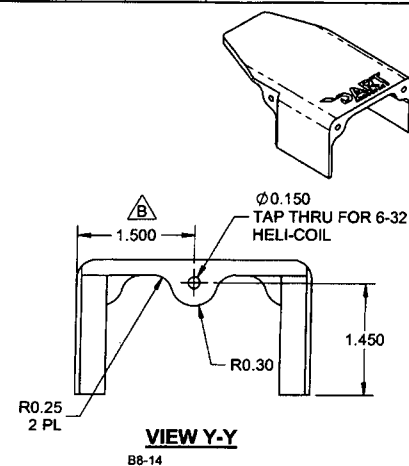
APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 13 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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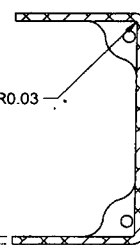
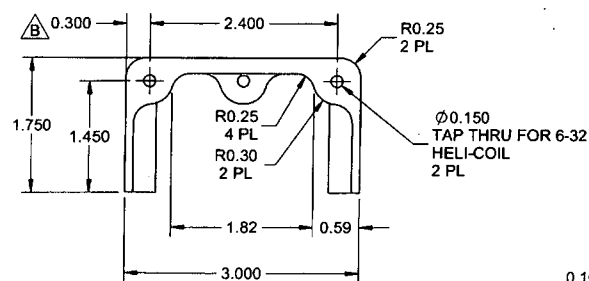
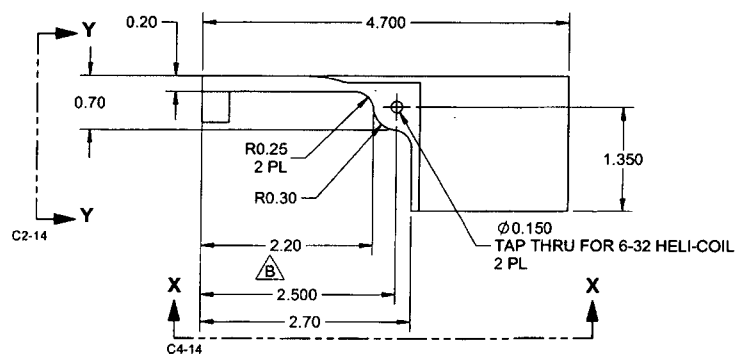
VIEW X-X

B6-14



VIEW Y-Y

B8-14



SECTION Z-Z

D6-14

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II
OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.36 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003-0.005 DP
- 8) UNDIMENSIONED FEATURES DEFINED BY D5155-11.SLDPR

D5155-11 CO-PILOT COLLECTIVE HEAD (212)

RELEASED

4.9. 2015 JUL 02

APPROVED

DESIGN	VS
DRAWN	VS
CHECKED	RF
MFG. APPR.	JFS
APPROVED	HS
DE APPR.	DS
DATE	15.05.21

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D5155 SHEET 14 OF 14
TITLE SCALE
CO-PILOT COLLECTIVE HEAD NTS

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DART AEROSPACE LTD		Work Order:	140053
Description: Co-pilot collective head (212)		Part Number:	D5155-11
Inspection Dwg: D5155 Rev: B		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.800	+0.010 / -0.000	2.801	✓		H-6	31006
1.83	+/-0.030	1.830	✓		"	"
R0.19	+/-0.030	R0.188	✓		R-6	ref.
21°	+/- 1/2°	21°	✓		Angle M.	CNC-17
0.227	+/-0.010	0.227	✓		H-6	31006
1.850	+/-0.010	1.846	✓		"	"
φ0.125 x 0.350	+0.041/-0.000 / +/-0.010	φ0.126 x 0.350	✓		Vern	GA-13
21°	+/- 1/2°	21°	✓		Angle M.	CNC-17
2.547	+/-0.005	2.544	✓		Vern	GA-13
0.35	+/-0.030	0.354	✓		"	"
R0.25	+/-0.030	R0.250	✓		R-6	ref.
0.35	+/-0.030	0.346	✓		Vern	GA-13
0.06	+/-0.030	0.063	✓		D-6	GA-08
0.33	+/-0.030	0.327	✓		Vern	GA-13
R0.25	+/-0.030	R0.250	✓		R-6	ref.
1.500	+/-0.010	1.500	✓		H-6	31006
φ0.150	+0.005 / -0.001	φ0.152	✓		Vern	GA-13
1.450	+/-0.010	1.450	✓		H-6	31006
R0.30	+/-0.030	R0.296	✓		R-6	ref.
R0.03	+/-0.030	R0.032	✓		"	"
0.100	+/-0.010	0.098	✓		Mic	GA-0311
3.000	+/-0.010	3.000	✓		Vern	GA-13
0.59	+/-0.030	0.596	✓		"	"
1.82	+/-0.030	1.808	✓		"	"
R0.30	+/-0.030	R0.296	✓		R-6	ref.
R0.25	+/-0.030	R0.250	✓		"	"
φ0.150	+0.005 / -0.001	φ0.152	✓		Vern	GA-13
R0.25	+/-0.030	R0.250	✓		R-6	ref.
2.400	+/-0.005	2.401	✓		Vern	GA-13
0.300	+/-0.010	0.300	✓		H-6	31006
1.450	+/-0.010	1.450	✓		"	"
1.750	+/-0.010	1.752	✓		"	"

Measured by: D.e	Checked by: 2U 9-RC	QC Inspector:
Date: 16/01/06	Date: 16-02-19	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

DART AEROSPACE LTD	Work Order:	140053
Description: Co-pilot collective head (212)	Part Number:	D5155-11
Inspection Dwg: D5155 Rev: B		Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by:	B.A	Checked by:	20 0.80	QC Inspector:	
Date:	16/01/06	Date:	16-02-19	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	K.	



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 911306

Date: 24-Feb-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE

Terms		Ship Via	
		BEST WAY	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
4 ea	Part: D5155-11 CO-PILOT REV BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 19203	Rev: B	PO: PO31446 Line:
4 ea	Part: D5155-043 CO-PILOT HEAD BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 19204	Rev: B	PO: PO31446 Line:
DATE: <u>24/2/16</u>			
CERTIFIED SIGNATURE: <u>[Signature]</u>			
RECEIVER SIGNATURE: _____			
Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. CERTIFICATE OF CONFORMANCE A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS. MADE IN CANADA.			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31446

Purchase Order Date 2/23/2016

PO Print Date 2/23/2016

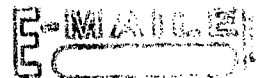
Page Number 1 of 6

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA



FEB 23 2016

Contact Name

Vendor Phone 613-446-4544

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA - (Free Carrier)

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	140053	DS155-11 CO-PILOT HEAD REV. B	2/24/2016 Yes 2/24/2016		4.00	\$18.51	\$74.06
Black Anodize per MIL-A-8625F Type I or IB or IC or II or IIB Class 2, Type III Class 2							
****RUSH PARTS****							
Line Total:							\$74.06
2	140223	DS155-043 CO-PILOT HEAD REV. B	3/23/2016 Yes 3/23/2016		4.00	\$18.51	\$74.06
Black Anodize per MIL-A-8625F Type I or IB or IC or II or IIB Class 2, Type III Class 2							
****RUSH PARTS****							
Line Total:							\$74.06

16/2/24
54

PO Instructions: admin fee included in unit price.

Note:

2/23/2016